

Work Order ID 57104

March 22, 2010 9:08:59 AM

Page 1

Item ID: D4059-041

Revision ID:

Item Name: Ski Section Assembly, Aft LH

Start Date: 3/22/10 Start Qty: 1.00

Required Date: 3/23/10 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4059

PAI Rev. A

100

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

Pick Kit

110

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1- Assemble as per Dwg D4059-041

2- Use wearplate to locate and to transfer drill holes in ski as per dwg and use 0.375" unibit to open wearplate mounting holes to finish size.

3- use wearbar to locate & transfer drill as per dwg. install wearbars.

120

0.00



QC

Memo

0.00

Quality Control

PROTOTYPE
PROTOTYPE
PROTOTYPE



Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



Wh 10/03/30 x1

Wh. 10/03/30 (x1)

1 1004.08

10/10/15
5001015
5001015
5001015

Work Order ID 57104

March 22, 2010 9:08:59 AM



Page 2

Item ID: D4059-041

Accept



Setup Start

Revision ID:

Stop

Item Name: Ski Section Assembly, Aft LH

Start Date: 3/22/10 Start Qty: 1.00

Required Date: 3/23/10 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

Quality Control

10/04/12

h 10/04/08

Picklist Print

March 22, 2010 9:08:58 AM

Page 1

Work Order ID: 57104

Parent Item: D4059-041

Parent Item Name: Ski Section Assembly, Aft LH


Comments: New Issue 10/03/16 Rev. A DL verified by:DD

Start Date: 3/22/10

Required Date: 3/23/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN4-6A  Bolt		Purchased	No			100	Each	1,239.000	10.0000			

Warehouse Location

Loc Qty

Loc Code

Main Warehouse

ST356

1239

112720

39

112829

300

112933

300

113149

600

D4059-1

Manufactured

No

100

Each

0.0000

1.0000

Batch 57102

Ski Section, LH

D4067-041

Manufactured

No

100

Each

0.0000

2.0000

56342

Joggled Wearplate

D4068-041

Manufactured

No

100

Each

0.0000

1.0000

56340

Curved Wearplate

1 OK 10/03/30
9 OK 10/03/30

OK 10/03/30

x2 OK 10/03/30

x1 OK 10/03/30

Picklist Print

March 22, 2010 9:08:58 AM

Page 2

Work Order ID: 57104

Parent Item: D4059-041

Parent Item Name: Ski Section Assembly, Aft LH


Comments: New Issue 10/03/16 Rev. A DL verified by:DD

Start Date: 3/22/10

Required Date: 3/23/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21043-4  Nut		Purchased	No			100	Each	725.0000	10.0000			

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
OFFSHORE		
FG	40	
104603	40	
Main Warehouse		
ST301	685	
112314	100	
112492	11	
113064	174	
114181	400	

NAS1149F0432P

Purchased

No

100

Each

403.0000

10.0000



Washer

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
Main Warehouse		
ST275	403	
110098	200	
112940	100	
18052	103	

March 22, 2010 9:08:58 AM

Shop Packet Print

Page 2

10 DL 10/03/30

10 DL 10/03/30

Picklist Print

March 22, 2010 9:08:58 AM

Page 3

Work Order ID: 57104

Parent Item: D4059-041

Parent Item Name: Ski Section Assembly, Aft LH


Comments: New Issue 10/03/16 Rev. A DL verified by:DD

Start Date: 3/22/10

Required Date: 3/23/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1149F0463P  Washer		Purchased	No			100	Each	229.0000	10.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST275	229	
108246	29	
114223	200	

10 DL 10/03/30

ANBC5A BOLT

M114108

x(12)

DL 10/03/31

M521043-3 Nut.

M112314

x(12)

DL 10/03/31

D4015-041 WEARBAR.

M53956

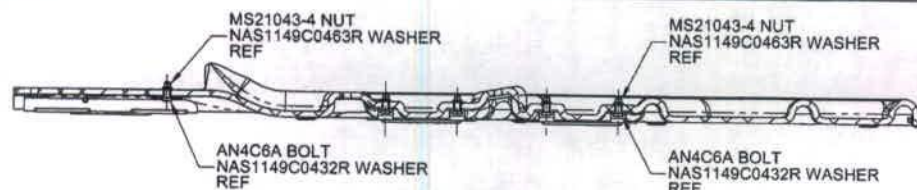
x(12)

DL 10/03/31

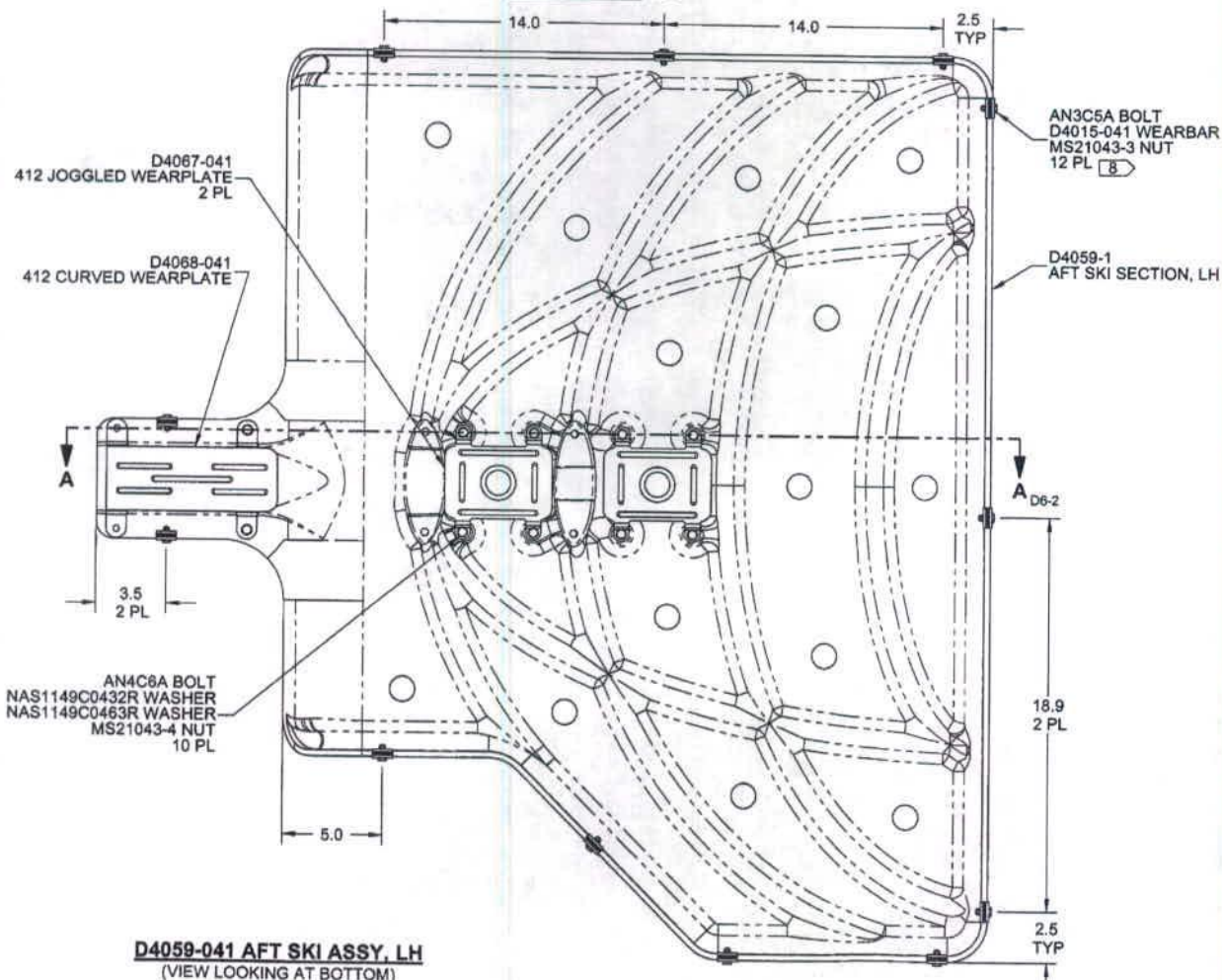
March 22, 2010 9:08:58 AM

Shop Packet Print

Page 3



SECTION A-A B4-2



ITEM	QTY -041	P/N	DESCRIPTION
1	X	D4059-041	AFT SKI ASSY, LH
2	12	D4015-041	WEARBAR
3	1	D4059-1	AFT SKI SECTION
4	2	D4067-041	412 JOGGLED WEARPLATE
5	1	D4068-041	412 CURVED WEARPLATE
6	12	AN3C5A	BOLT
7	10	AN4C6A	BOLT
8	12	MS21043-3	NUT
9	10	MS21043-4	NUT
10	10	NAS1149C0432R	WASHER
11	10	NAS1149C0463R	WASHER

D4059-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 26.0 lbs
- 8) LOCATE D4015-041 (ITEM 2) AS SHOWN.
TRANSFER DRILL $\varnothing 0.191$ " HOLE FROM D4015-041 TO D4059-1.
CHAMFER HOLE 0.03 X 45°.
FASTEN USING PRESCRIBED HARDWARE
- 9) TORQUE: AN3 NUTS = 15-20 in-lb
AN4 NUTS = 50-70 in-lb

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4059	SHEET 2 OF 8
APPROVED		TITLE	SCALE
DE APPR.		AFT SKI ASSY	NTS
DATE	10.03.31	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND PROPRIETARY AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

RELEASED
2010-04-07
MMD

W/O 57104

